

Date: Friday, 9/21/2007 12:59:21 PM
User: Kim Johnston

Process Sheet

42

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 GHW ADAPTER
Job Number : 34773	
Estimate Number : 10571	
P.O. Number :	Part Number : D206651041
This Issue : 9/21/2007 S.O. No. :	Drawing Number : D206-651 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 31296	Material :
Written By :	Due Date : 10/20/2007 Qty: 80 Um: Each
Checked & Approved By : <u>AS 07.09.24</u>	
Comment : Est Rev: F 02.08.14 Re-format KJ	
Est Rev: G Removed Purchasing 07-03-21 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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(26)

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-651-041 CHG001

KS 07.09.26

2.0	D2692	Spring Pin Clip
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2692	Spring pin	34082

AS 08/02/25 (x26)

3.0	D2711	Lock Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2711	Pin	34792

AS 08/02/25 (x26)

4.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	3405792 M100552

AS 08/02/25 (x26)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 GHW ADAPTER

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Part Number: D206651041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

CBL1240

Cable



Comment: Qty.: 1.7500 f(s)/Unit Total : -52.5000 f(s)

Pick:

Qty Part Number Description Batch

21" CBL-1240 Cable

~~M102437~~ 103927

AS 08/02/25 (x26)

6.0

CBL460

Loop Sleeve



Comment: Qty.: 4.0000 Each(s)/Unit Total : -120.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 CBL-460 Loop sleeve

~~M103927~~

M103927

AS 08/02/25 (x26)

7.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L3 Nut

~~M105558~~ 106589

AS 08/02/25

8.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

~~M105076~~ 106589

AS 08/02/25

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut cable CBL-1240 in half (10.5" each) Remove 2.25" of sleeve from each end of cable CBL-1240

2-Crimp CBL-460 onto CBL-1240 to make (2) D2690-8 as per Dwg D2690. (Leave one end open)

3-Install Lanyard D2690-8 (from open end) into pin D2711 and assemble screw, washer and nut as per Dwg D206-651.

4-Install Lanyard D2690-8 into spring pin D2692 and assemble screw, washer and nut at other loop as per Dwg D206-651.

MF 08-02-27 (x26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 12:59:21 PM
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Process Sheet

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Drawing Name: 206 GHW ADAPTER

Job Number: 34773

Part Number: D206651041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/03/05 (26)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-651-041 CHG001

Location: _____

PPP Rev: _____

PK

8/2/13 50 26

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/03/04

Job Completion



mi 2008/3/04 (26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

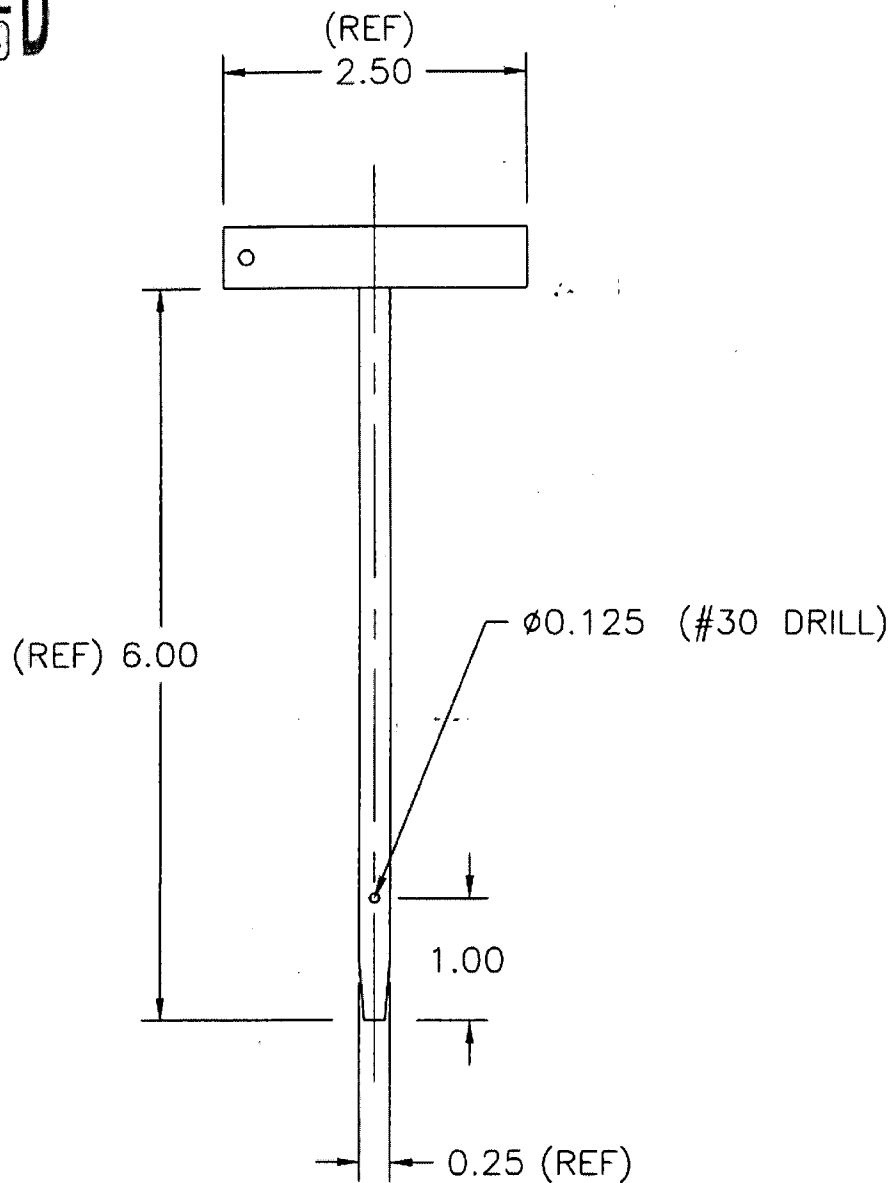
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>DM</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>AS</i>	APPROVED <i>AS</i>	DRAWING NO. D2711	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LOCK PIN	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



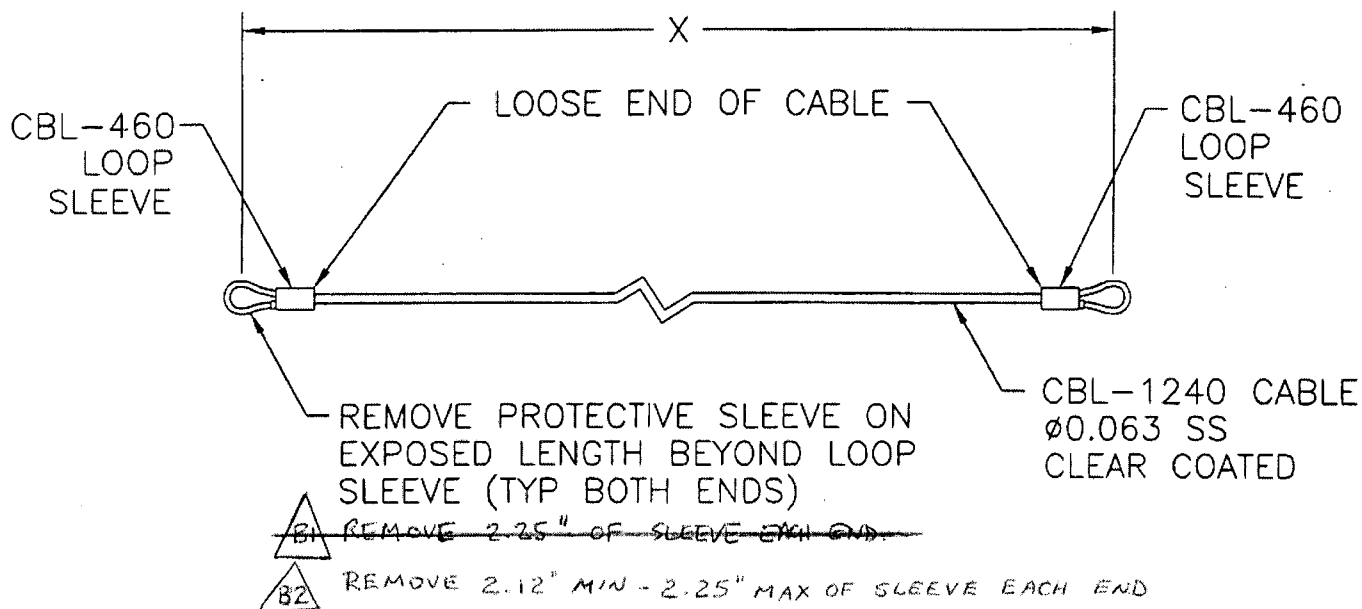
MAKE FROM REID TOOL SUPPLY PART # PNT-9
FINISH: CAD PLATE

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34773



DESIGN <i>ME</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	CP 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	KE 04.06.24	ADDED TOLERANCE	

RELEASED
971003 KE
TSR A374



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH. FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH SLEEVE AT END OF LOOSE END OF CABLE WITH CBL-705 CRIMPING TOOL.
*ADDITIONAL LENGTH MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER ASSEMBLY WITH ATTACHING PARTS.

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WORK ORDER
NO. 34773

DEO's